

Work Order ID 62766



Page 1

Thursday, October 07, 2010 3:13:37 PM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 10-10-07 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274	D								
IIN-D206-642	Rev M								

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A CY 10/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004
AR Aluminum Rod Batch # M11385

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP BB 10-10-13
10/10/14
M115778 BE 10/10/14
BE 10/10/14
DP BB 10-10-18

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				①			BB 10/10/19
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			10/10/19
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			10/10/19

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 11/5/11 ☐

Sikaflex expire date: ☐ 11/01/10 ☐

Start: ☐ 2:35 10/07/10 ☐ 2:35 ☐

Finish: ☐ 10/07/10 ☐ Time: ☐ 10:30 AM ☐

(Adhere for 12 hours)

DP 10-10-19
BB 10/11/03

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/11/09

(X)

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

h=2.9125

L=4.40

Solulob

10-11-8

BB 10/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Skidtubes	0.00							
Skidtubes	Memo 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side: Use aluminum rod A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>m11385</u> 3-Grind cross bolt welds flush as per Dwg D3274. 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.	0.00							
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo <i>80/11/11</i>	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
220 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00 0.00							
230 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:25 OVEN TEMPERATURE: 320° FINISH TIME: 1:55	0.00 0.00							

(70)

1 0

L BT 10-11-15.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  HandFinish Hand Finishing	HAND FINISHING RESOURCE #1 Memo 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 11/5/14 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 11/01 3-Inspect for foreign objects as per QSI 024 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: N/A 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 11/5/14 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 11/01	0.00 <i>2.00</i> 0.00		10/11/18		1	0		
280  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		10/14/18					

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P/N 63386

0.00

Packaging

6/19/10

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/13

MSF
10-12-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010



Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM[]
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	73.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>73</div> <div></div> </div>													
<div> <div>47575</div> <div>25</div> <div></div> </div>													
<div> <div>59874</div> <div>48</div> <div></div> </div>													
D3285-1  Cap		Manufactured	No			110	Each	141.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>141</div> <div></div> </div>													
<div> <div>52511</div> <div>74</div> <div></div> </div>													
<div> <div>52647</div> <div>67</div> <div></div> </div>													
D3282-041  Float Web (206L/407)		Manufactured	No			150	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>2</div> <div></div> </div>													
<div> <div>59886</div> <div>2</div> <div></div> </div>													
<div> <div>60931</div> <div></div> <div></div> </div>													

① DP 10-10-13

T BE 10-10-14

1 BB 10/11/03

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Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

65.0000

1 1



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

65

58545

2

60652

4

61496

59



B 63359 (v12) BE10/11/10

D3275-1

Manufactured No

190 Each

216.0000

12 12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

216

53453

8

61646

102

62399

106



E 7 BE10/11/10

CR3212-4-03

Purchased No

250 Each

1,888.000

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1888

111359

5

112314

2

114436

448

114450

71

114859

1362



M 10/11/18

D3415-041

Manufactured No

250 Each

52.0000

1 1



Nut Plate

Location

Loc Qty

Loc Code

ST056

52

33842

52



M 10/11/18

V1

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Shop Packet Print

Page 2

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Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

446.0000

2

2



Cherry Rivet



10/11/18

Location

Loc Qty

Loc Code

ST311

446

112314

4

113539

44

113973

398

X2

ALS4-1032-130

Purchased

No

250

Each

1,147.000

78

78



Insert



10/11/18

Location

Loc Qty

Loc Code

PKG11

1098

114723

1098

ST282

10

110511

10

ST381

39

114654

39

V78

M115911

D3536-15

Manufactured

No

270

Each

21.0000

1

1



Gasket



10/11/18

Location

Loc Qty

Loc Code

FP

9

56055

1

60875

8

FP11

12

59238

1

62459

11

X1

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Start Qty: 1.00

Required Qty: 1.00

D3536-23	Manufactured	No	270	Each	8.0000	1	1
							<u>HL 10/11/18</u>
Gasket							

Location

Loc Qty

Loc Code

FP011



8

B63238

Y1

61237

8

D3536-35	Manufactured	No	270	Each	23.0000	1	1
							<u>HL 10/11/18</u>
Gasket							

Location

Loc Qty

Loc Code

FP012

23

B63579

Y1

58683



1

61692

10

62462

12

D3536-39	Manufactured	No	270	Each	12.0000	1	1
							<u>HL 10/11/18</u>
Gasket							

Location

Loc Qty

Loc Code

FP12



12

58215

1

58571

11

D3535-15	Manufactured	No	270	Each	12.0000	1	1
							<u>HL 10/11/18</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP18

12

B62707

Y1

61241

6

62241

6

Thursday, October 07, 2010 3:13:42 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:42 PM

Page 5

Work Order ID: 62766

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-35	Manufactured	No	270	Each	8.0000	1	1
							<u>HL 10/11/18</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP018



8

B62461

60865

8

xl

D3535-39	Manufactured	No	270	Each	17.0000	1	1
							<u>HL 10/11/18</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP18

17



58214

1

60233

16

xl

D3535-23	Manufactured	No	270	Each	19.0000	1	1
							<u>HL 10/11/18</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP

7

61830

7

FP021



20

B62706

60231

11

xl

D3537-3	Manufactured	No	270	Each	6.0000	1	1
							<u>HL 10/11/18</u>
Wearpad							

Location

Loc Qty

Loc Code

FP17

6

B61674

60866

6

xl

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:42 PM

Page 6

Work Order ID: 62766

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 270 Each 14.0000 9 9
Wearpad

Location

Loc Qty

Loc Code

FP 55465
FP017 61986
FP17 57713
60491
61640

1
1
6
6
7
3
3
1

B62928

X9

AN960C10L NAS1149C0332 Purchased No 270 Each 29.0000 80 80

washer

Location

Loc Qty

Loc Code

ST245 107534

29
29

M115832

x80 10/11/18

AN960C416 NAS1149C0463 Purchased No 270 Each 100.0000 1 1

washer

Location

Loc Qty

Loc Code

ST346 100993

100
100

M115358

X1

Thursday, October 07, 2010 3:13:42 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:42 PM

Page 7

Work Order ID: 62766

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 270 Each 855.0000 2 2
Phenolic Washer



HL 10/11/18

Location	Loc Qty	Loc Code
ST077	855	
42329	150	
52505	705	

AN3C4A Purchased No 270 Each 1,650.000 80 80
BOLT



HL 10/11/18

Location	Loc Qty	Loc Code
ST245	20	
110139	20	
ST303	42	
115438	42	
ST350	1588	
114108	14	
114416	12	
114523	2	
115300	560	
115589	1000	

AN4C5A Purchased No 270 Each 489.0000 1 1
BOLT



HL 10/11/18

Location	Loc Qty	Loc Code
ST346	489	
110552	4	
112243	485	

XL

Thursday, October 07, 2010 3:13:42 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:42 PM

Page 8

Work Order ID: 62766

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

44.0000

1

1



ul

10/11/18

Aft Cap

Location

Loc Qty

Loc Code

FP-4

39

57332

39

X1

fp5

1

61752

1

FP6

4

52663

4

D3413-1

Manufactured No

270

Each

31.0000

1

1



ul

10/11/18

Ring

Location

Loc Qty

Loc Code

ST473

31

51586

1

53446

15

61322

15

X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.02.12
DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

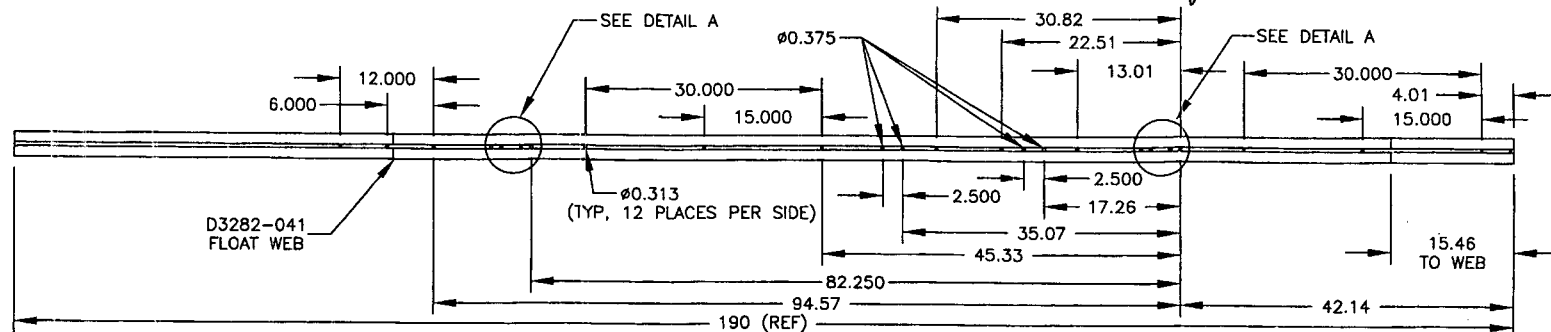
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

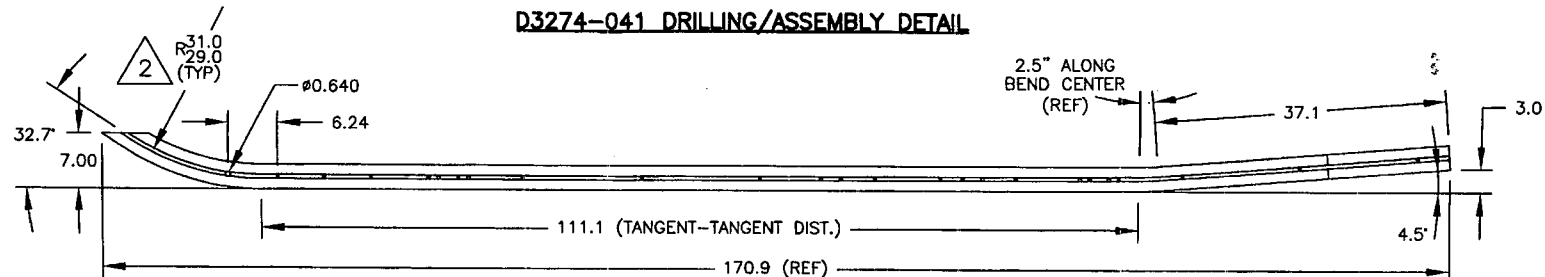
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

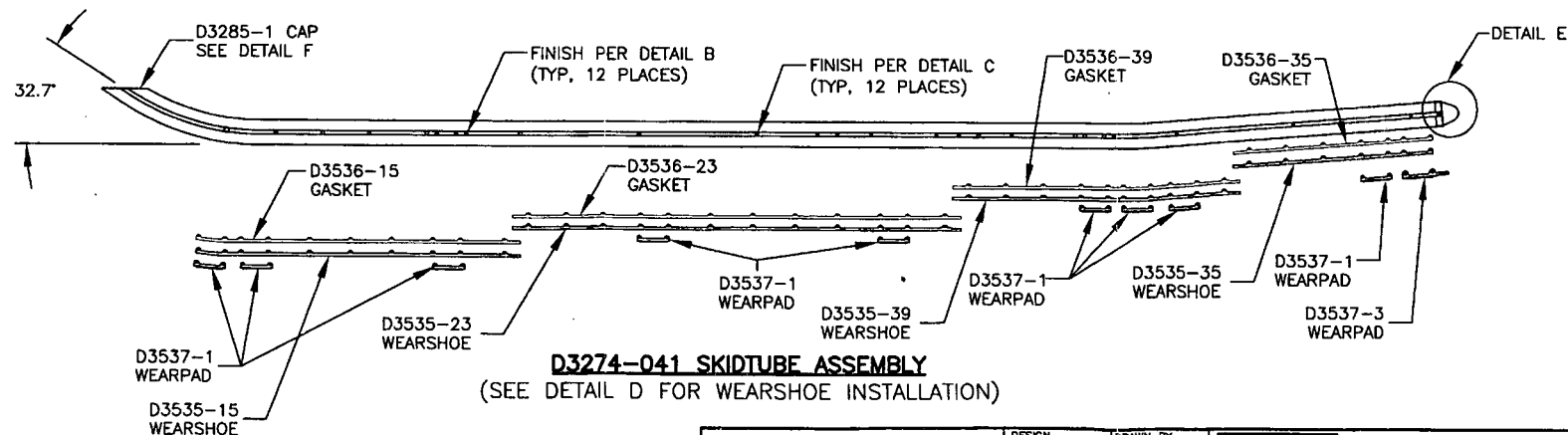
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC.	REV. D
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

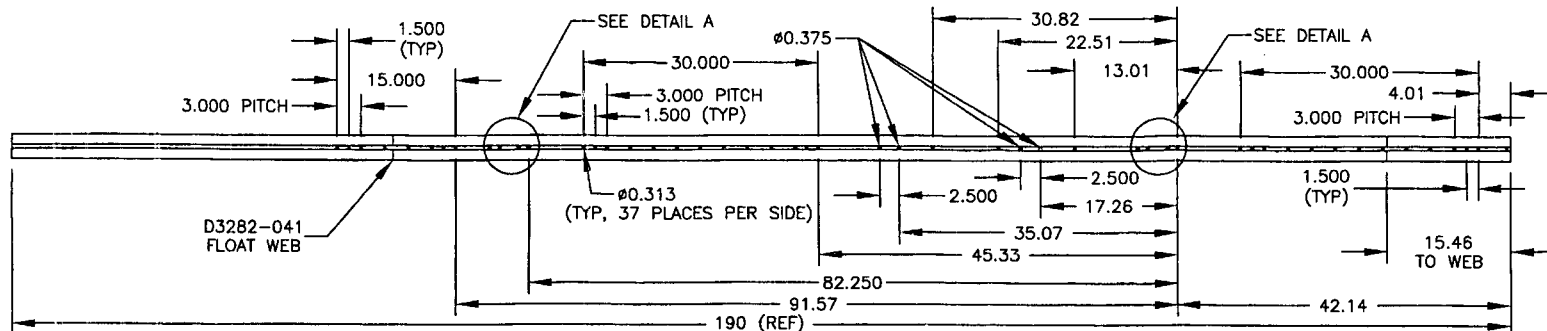
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

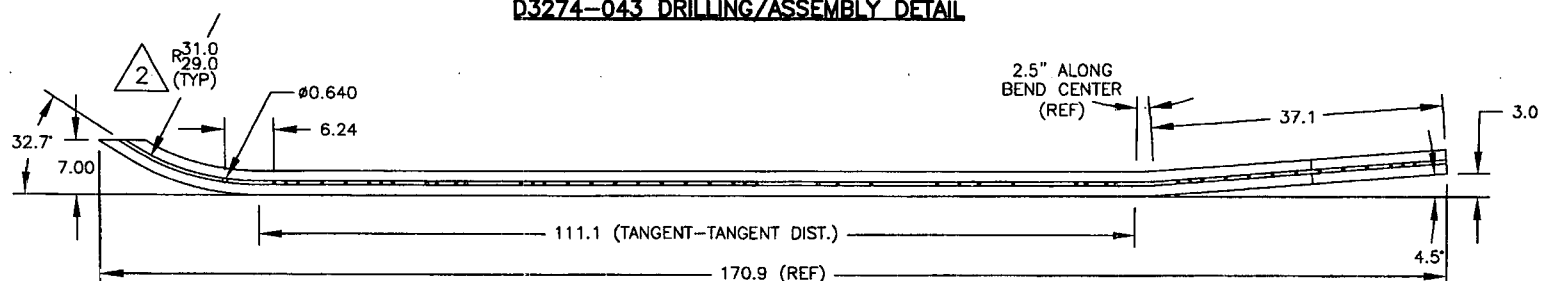
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

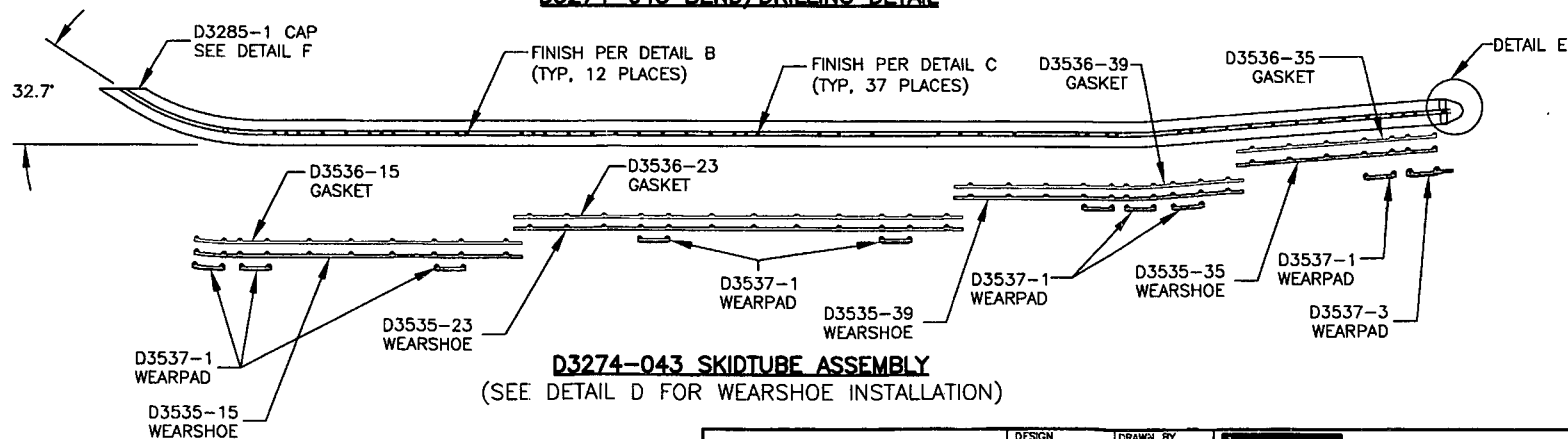
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3274	REV. D SHEET 3 OF 4
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

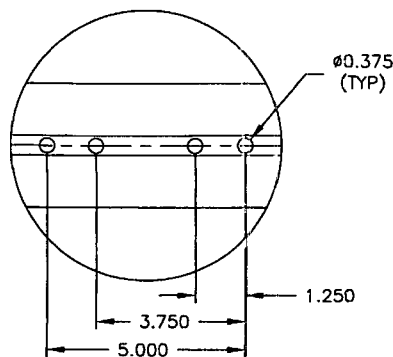
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

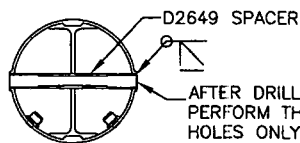
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

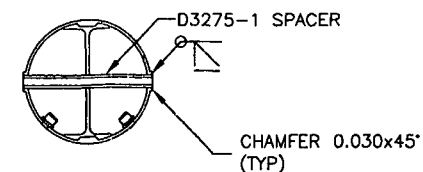


DETAIL B FOR 0.375 HOLES ONLY

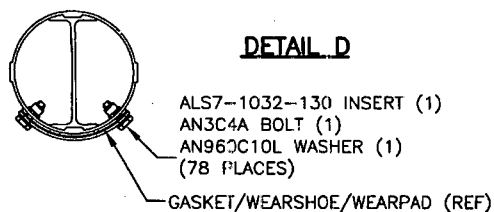


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



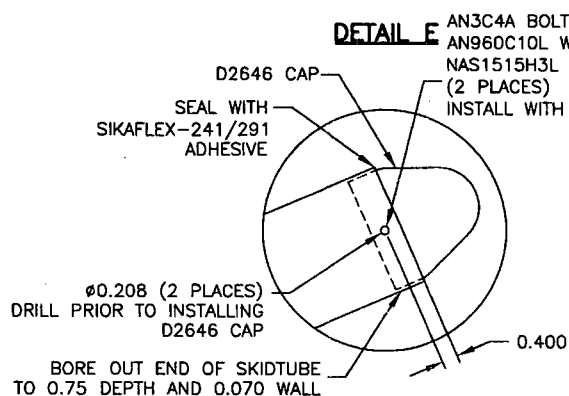
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

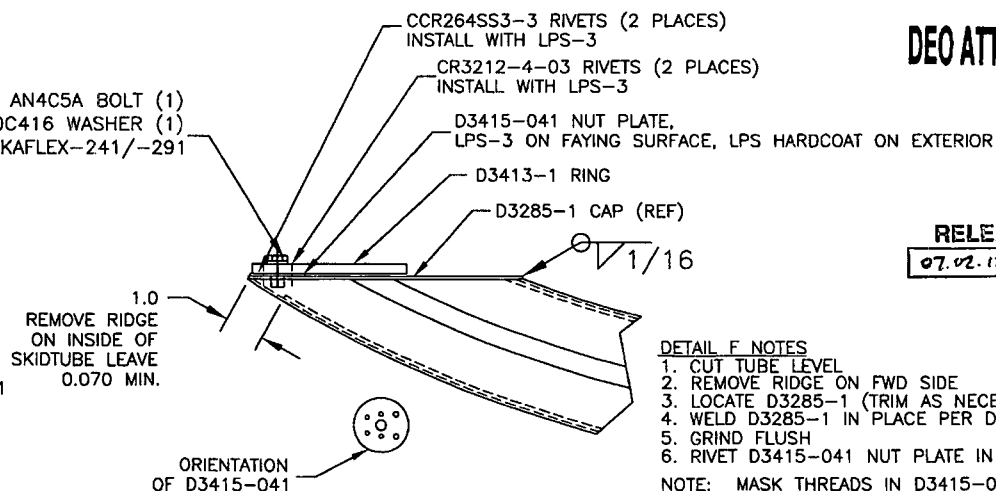
DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

DETAIL F: END FINISHING DETAIL



REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

- CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3
CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

DEO ATTACHED

RELEASED
07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	06.12.19	D3274	SHEET 4 OF 4
		TITLE	SCALE
		SKIDTUBE ASSEMBLY	1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

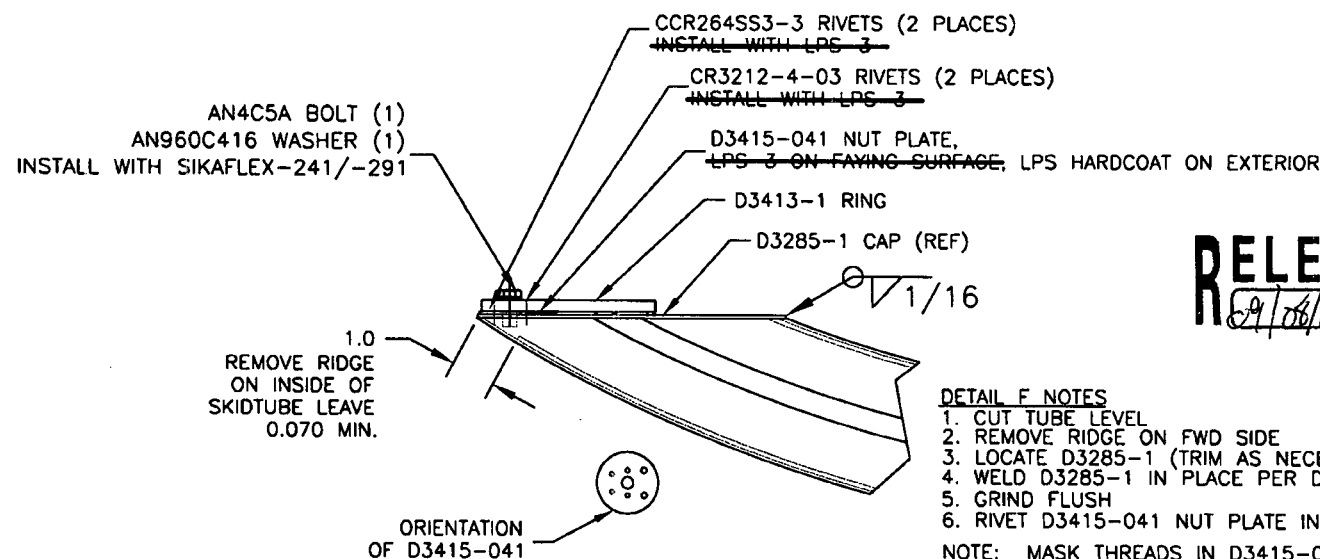
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>2</i>	MFG. APPR. <i>A</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622508
Part number: D206-442-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 10.09.30
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.